

Work Order ID 85842

85842

Page 1

Item ID: D4155-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 15/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/15 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4155

C

100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 91.59"

SL 12-06-19

(12)

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio FB048 & dwg D4155,

FOLIO REV: AA

DWG REV: C

2-Deburr as required

SL/JS 12-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief-Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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June-15-12 1:36:20 PM

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>H/E</i>	12-06-23		<i>(12)</i>	<i>0</i>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>ml 12/06/24</i>			<i>12</i>	<i>0</i>		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>W/A</i> Memo	0.00 0.00				<i>(12)</i>	<i>ml</i>	<i>12-07-23</i>	

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

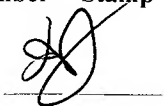
150

QC

Memo

0.00

Quality Control

12/7/24 MF
12-07-24

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Picklist Print

June-15-12 1:36:23 PM

Page 1

Work Order ID: 85842

85842

Parent Item: D4155-1

D4155-1

Parent Item Name: Bar

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC
11.04.14 as per dwg revB DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	735.9840	7.6333	96.42063			

M304B0 250x0 500

304 BAR .250 x .500

SL 12-06-19

Location

Loc Qty

Loc Code

MAT050

735.984

121216

142.08

121547

89.904

122008

504

96.43

Dart Aerospace Ltd

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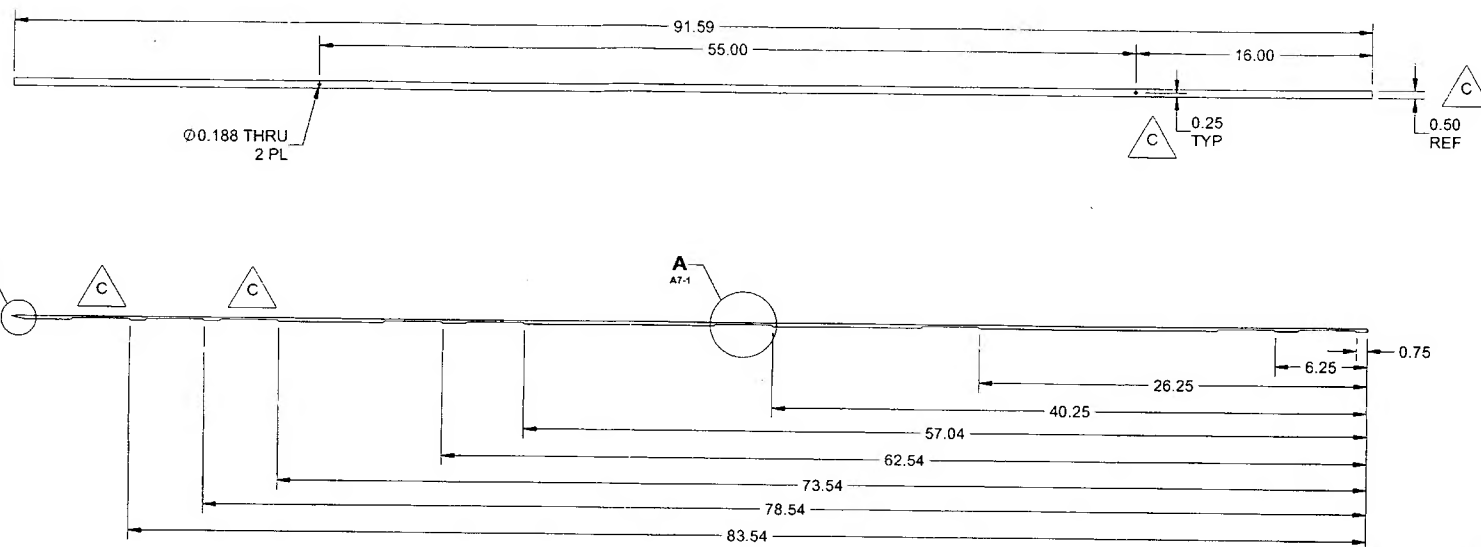
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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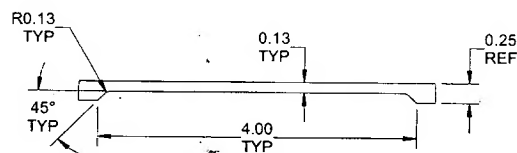
8 7 6 5 4 3 2 1



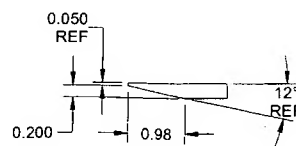
D4155-1 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85842 MLJ
12/06/15

REL 2012-04-11



DETAIL A D4-1
SCALE 2X, TYP



DETAIL B C7-1
SCALE 2X

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.69 lbs

REV.	DESCRIPTION	BY	DATE
C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (ZN, C6-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4155 REV. C SHEET 1 OF 1 TITLE BAR SCALE NTS DATE 12.02.21 COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			

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